

Date: Wednesday, 10/31/2007 3:26:03 PM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	MOUNTING LUG
Job Number	35470		
Estimate Number	10256		
P.O. Number	N/A	Part Number	D22303
This Issue	10/31/2007	S.O. No.	N/A
Prsht Rev.	NC	Drawing Number	D2230 REV F
First Issue	N/A	Project Number	N/A
Previous Run	35013	Drawing Revision	F
Written By		Material	N/A
Checked & Approved By	<u>DK</u> 10/31/01	Due Date	11/15/2007
Comment	Qty: 294 300 Um: Each Est D 08.05.18 Added inspection level 8, and removed P/O for powder coat EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D2423	Lug Extrusion    <b>Comment:</b> Qty.: 0.0717 f(s)/Unit Total : 21.5145 f(s) Lug Extrusion D2423 Batch: <u>B33310</u>
2.0	BAND SAW	BAND SAW    <b>Comment:</b> Band Saw Cut D2423 extrusion to 0.82" Batch:
3.0	HAAS	HAAS CNC VERTICAL MACHINING #1    <b>Comment:</b> HAAS CNC VERTICAL MACHINING #1 Machine per folio D2230-3 drawing D2230 Rev F Metec Check for crack while loading into the machine.
4.0	QC5	INSPECT PARTS AS THEY COME OFF MACHINE    <b>Comment:</b> INSPECT PARTS AS THEY COME OFF MACHINE
5.0	QC5	SECOND CHECK    <b>Comment:</b> SECOND CHECK Inspect level 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 01/11/06  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG

Job Number: 35470

Part Number: D22303

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble and deburr rough edges after tumbling

*u/4*

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

*HS*

07-11-21

294X

8.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*HS 07/11/21*

*X294*

9.0 POWDER COATING

POWDER COATING



*M105914*

*294X*

Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

*HS 07/11/23*

10.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



*HS KB*

Comment: INSPECT POWDER COAT/INSPECT POWDER COAT

07-11-23

X294

11.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 476

*HS 07/11/26*

294

12.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*07/11/26*

*u 07.11.26*

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

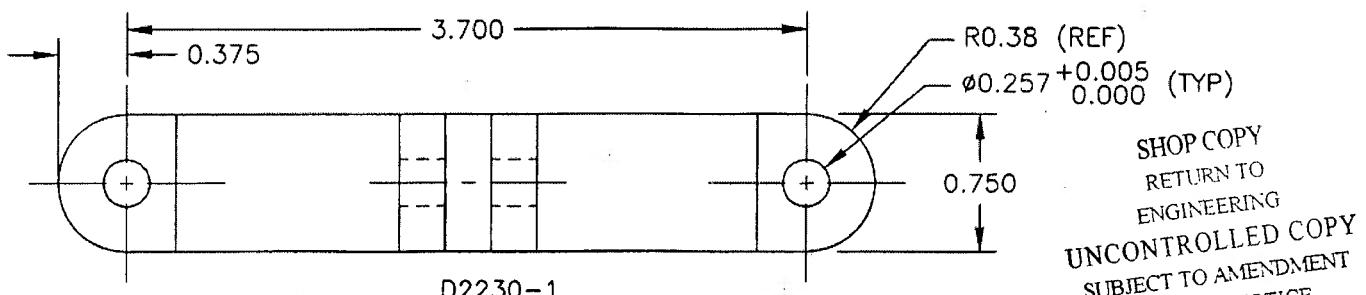
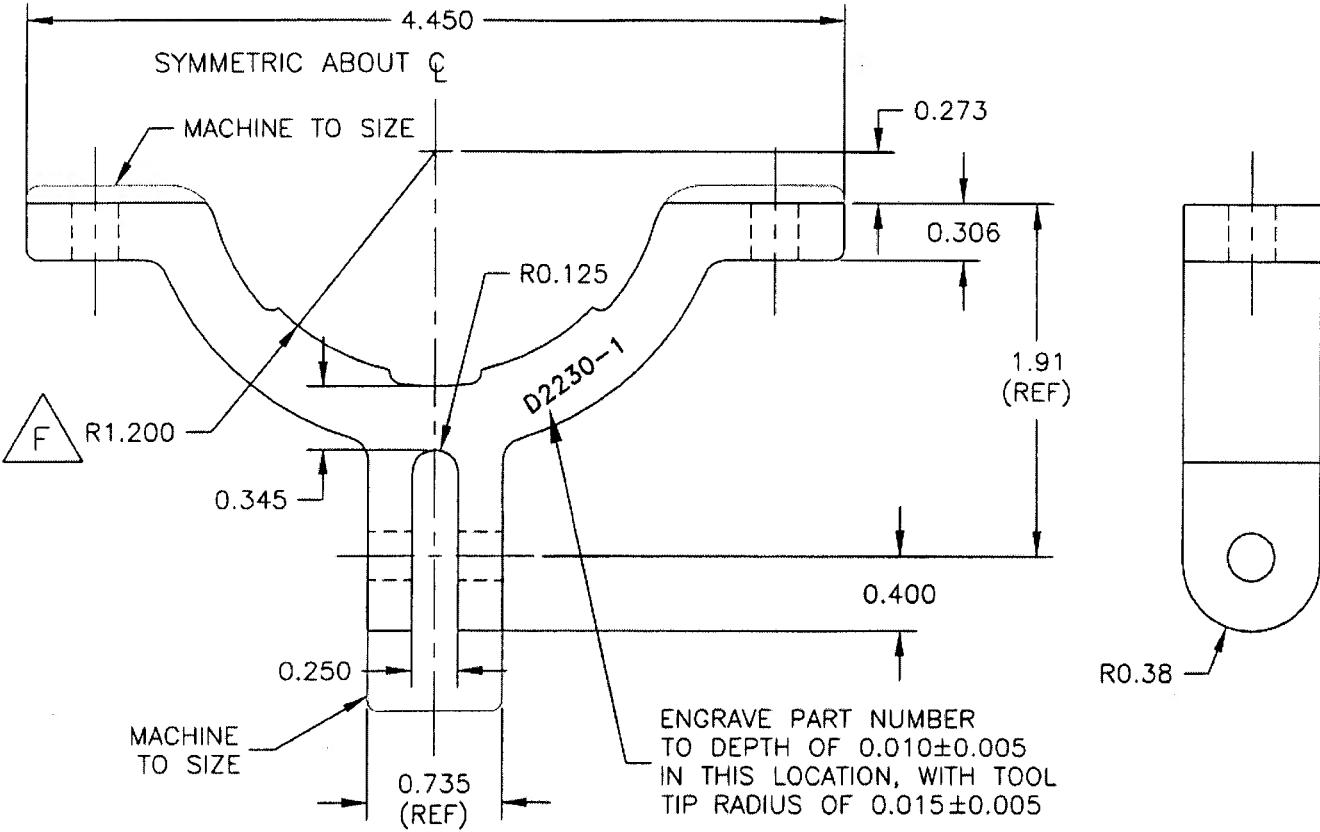
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**GACOPY ISSUED  
BY DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2230 REV. F SHEET 1 OF 2
DATE		SCALE 1:1
99.12.13		MOUNTING LUG
C	94.03.30	RE-DESIGN
D	95.01.04	RE-DESIGN
E	95.01.04	RE-DESIGN
F	99.12.13	REDESIGN; R1.200 WAS R1.100

**RELEASED**  
99.12.21 PS

MAKE FROM EXTRUSION D2423  
BREAK ALL EDGES 0.000-0.015

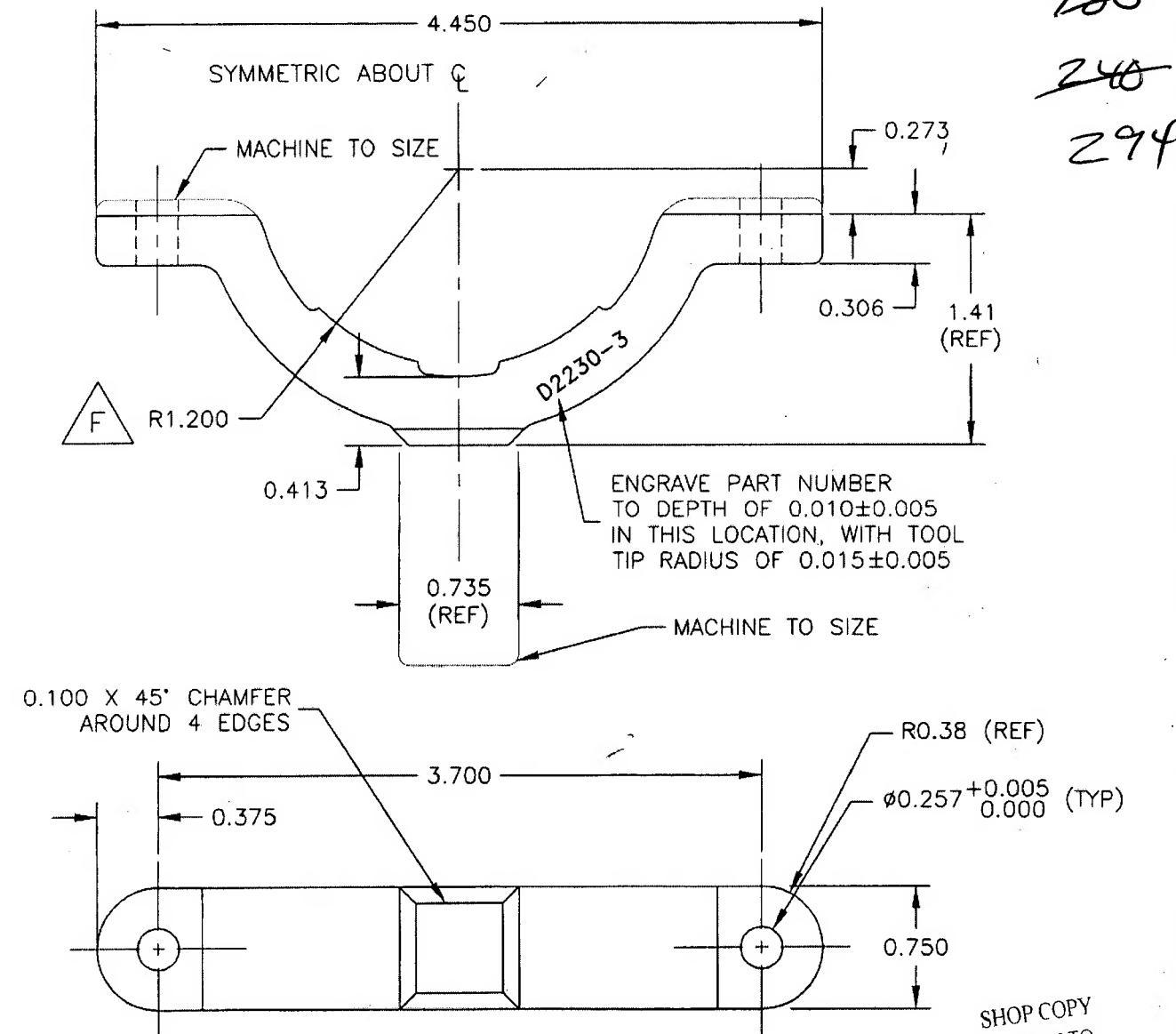
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 35470

**DART**COPY ISSUED  
04

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2230
DATE		TITLE MOUNTING LUG

REV. F  
SHEET 2 OF 2  
SCALE 1:1

**RELEASED**  
99.12.21 DS

MAKE FROM EXTRUSION D2423  
 BREAK ALL EDGES 0.000-0.015  
 FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
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 WORK ORDER  
 NO. 35470

**CERTIFICATE OF CONFORMITY****SOLD TO:**

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, Ont.  
K6A 1K7

**SHIPPED TO:**

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
294	D2230-3	Lug B35470	4954

MATERIAL: supplied by DART D2423 B33310

We hereby certify that the above parts were made in conformance with applicable drawings.

*METEC Metal Technology Inc.*

A handwritten signature in black ink, appearing to read "Shigi Walz".

Vankleek Hill, November 19, 2007